



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2432
Job Sheet 170093



Part No: D2432

Job Qty: 20 ea

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/26/18

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Great Slave Helicopters Ltd (CGREA01)

Accounting Office, 6285 Airport Way Kelowna, BC, V1V 1S1 Canada ph:(403) 286-2040 fx:(250) 765-0077.

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	1/24/18	1/24/18	0.00	0.00	Start Up Container		DL 18/01/10
120	Waterjet	20 pcs	1/24/18	1/24/18	0.00	5.15	Waterjet1		DL 18/01/10
130	CNC Vertical Machining	20 pcs	1/26/18	1/26/18	0.36	25.67	HAAS 1		SC 17/01/26
140	QC	20 pcs	1/26/18	1/26/18	0.00	0.00	QC2		SC 17/01/26
150	QC	20 pcs	1/26/18	1/26/18	0.00	0.00	QC8		PM 18/02/05
160	Packaging	20 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3		DAS 17/01/26
170	QC21-SA	20 Ea	1/26/18	1/26/18	0.00	0.00	QC21		21

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	74	836	0	0

DART
AEROSPACE
S031529



Bearpaw 19" X 24"

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D2432
Revision:
Operation:
Change No:

Start up Operation

Mfg Date: 01/11/18
Job No: 170093

Part Specifications
Specifications could not be found.

Plex 1/10/18 7:30 AM dart.lacelle.linda

DART AEROSPACE LTD		Work Order: 170093
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45	✓		Ver	
B	0.200	+/-0.030	0.205	✓		Ver	ED-6
C	0.25 x 45°	+/-0.030	0.250 x 45°	✓		"	"
D	R0.250	+/-0.030	0.250	✓		R.G.	
E	0.250	+/-0.010	0.250	✓		Ver	ED-6
F	0.625	+/-0.030	0.610	✓		Ver	"
G	0.375	+0.030/-0.010	0.370	✓		"	"
H	0.950	+0.030	0.940	✓		"	"
I	19.000	+/-0.030	19.000	✓		TAPE	
J	Ø0.260	+0.005/-0.000	0.260	✓		G.P.	
K	Ø0.93	+/-0.030	0.931	✓		Ver	ED-6
L	0.30	+0.030/-0.000	0.315	✓		"	"
M	23.750	+/-0.030	23.750	✓		TAPE	
N	2.000	+/-0.030	2.000	✓		Ver	"
O	0.38	+/-0.030	0.380	✓		"	"
P							
Q							
R							
S							
T							
U							
V							

Measured by: SBL JC	Audited by: ml	Preliminary Approval:
Date: 18/01/04	Date: 18/02/05	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	